

LENGTHS CON'T.

Where billet size does not allow the length Requirements to be met, prior approval is required. Up to 10% allowance is given for longer or shorter bar lengths. Lengths under 10' are not acceptable.

FINISH: The finish stated in the item description on the Purchase Order must meet the following Requirements:

Smooth Turned(ST) or Cold Drawn(CD) - Aim for a maximum surface finish of 50RMS GUARANTEE 70MAX. RMS (bright finish with no or light turn marks, degreased and diameter tolerance as per ASTM A484, polishing or grinding may be required to meet this requirement).

CD Round Bars are acceptable for bars ordered as ST provided bars are surface defect free.

Rough Turned Bars(RT) - Guarantee a maximum surface finish of 125RMS through 8", 250 RMS over 8" (bright finish with slightly heavier turn marks, degreased and diameter tolerance as per ASTM A484). Bars must be capable of clean-up to nominal size ordered and defect free on size.

Hot Rolled Annealed and Pickled (HRAP) - Rough finish (imperfections shall not exceed ASTM A484).

All bars must be free of surface rust contamination.

SCRATCHES: The processing and handling of bars must be done in a manner which surface scratching is minimized and no scratching should exceed ASTM A484.

ROUGH TURNED DIAMETER ALLOWANCE:

Rough Turned Bar shipped to ENERGY STEEL PRODUCTS should typically have the following diameter tolerance to allow clean-up to size.

3" to 3-1/2"	+.020/+ .035
over 3-1/2" to 4-1/2"	+.030/+ .045
over 4-1/2" to 5-1/2"	+.040/+ .060
over 5-1/2" to 6-1/2"	+.080/+ .100
over 6-1/2" to 8"	+.090/+ .120
over 8" to 10"	+.100/+ .140
over 10" to 12"	+.100/+ .140
over 12" to 15"	+.125/+ .185
over 15" to 22"	+.125/+ .200

ROUGH TURNED DIAMETER ALLOWANCE CON'T.

Rough Turned Bar shipped to UNALLOY-IWRC should typically have the following diameter tolerances to allow clean-up to size.

3"	to 3-1/2"	+.010 - .000
3-1/2"	to 5"	+.015 - .000
over 5"	to 6.75"	+.032 - .000
over 6.75"	to 18"	+.063 - .000

Rough Turned Straightness – 1/8 in 5' Cold Finish Straightness tolerance is required.